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Hawkesbury, ON
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U/R

SM
19/04/17

D3512-3

Job Sheet 193653



Part No: D3512-3

Job Qty: 18 pcs

Part Name: Spacer



Part Weight: 0 lbs

Job Created: 4/17/19

Due Date: 4/30/19

Type: SOLD

Status: New

Priority: Medium

Job Tracking No:

Created By: Linda Lacelle

Description:

Note: URF DWG D3512 REV.D IPP REV:A 13.07.19 NEW ISSUE DD VERF:JLM IPP REV:B 13.12.11 ECN13-619/
REV.D DWG DD VERF:JLM IPP REV:C 18.03.12 DWG REV.E12 DD VERF:JFS

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Waterjet - Flow - 1	18		4/30/19	0.00	1.22	Waterjet - Flow		2019/04/24
	cut REV.EA Prelim	pcs							
110	QC 2	18		4/30/19	0.00	0.00	QC 2 - 1		2019/04/25
		pcs					QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		
							QC 2 - 49		
							QC 2 - 50		
							QC 2 - 51		
							QC 2 - 52		
							QC 2 - 57		
							QC 2 - 62		
							QC 2 - 63		
							QC 2 - 8		
							QC 2 - 66		
							QC 2 - 64		

120	QC 8	18 pcs	4/30/19	0.00 0.00	QC 2 - 65	
					QC 2 - 5	
					QC 2 - 71	
					QC 8 - 12	
					QC 8 - 14	
					QC 8 - 17	
					QC 8 - 20	
					QC 8 - 25	
					QC 8 - 3	
					QC 8 - 32	
					QC 8 - 33	
					QC 8 - 35	
					QC 8 - 39	
					QC 8 - 4	
					QC 8 - 44	
					QC 8 - 45	
					QC 8 - 49	
					QC 8 - 58	
					QC 8 - 8	
					QC 8 - 9	
					QC 8 - 68	
					QC 8 - 67	
					QC 8 - 1 (A)	
					QC 8 - 47	
					QC 8 - 40	APR 25 2019
					QC 8 - 52	
					QC 8 - 23	
130	Small Fab - Brake NC - B4B	18 pcs	4/30/19	0.24 0.41	Small Fab - Brake - 1 - B4B	
					Small Fab - Brake - 2 - B4B	
					Small Fab - Brake - 3 - B4B	
140	QC 5	18 pcs	4/30/19	0.00 0.00	QC 5 - 10	
					QC 5 - 12	
					QC 5 - 17	
					QC 5 - 18	
					QC 5 - 19	
					QC 5 - 22	
					QC 5 - 24	
					QC 5 - 3	
					QC 5 - 43	
					QC 5 - 49	
					QC 5 - 51	
					QC 5 - 58	
					QC 5 - 68	
					QC 5 - 9	
					QC 5 - 50	
					QC 5 - 30	
					QC 5 - 40	
150	Packaging 3-1 - Stock - B4B	18 pcs	4/30/19	0.00 0.00	Packaging 3 - 1 - B4B	
					Packaging 3 - 2 - B4B	
					Packaging 3 - 3 - B4B	
					Packaging 3 - 4 - B4B	
					Packaging 3 - 5 - B4B	
					Packaging 3 - 6 - B4B	
					Packaging 3 - 7 - B4B	
					Packaging 3 - 8 - B4B	
					Packaging 3 - 9 - B4B	
					Packaging 3 - 10 - B4B	

DAS
40
9-89

2019

APR 29 2019

DAS
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9-89

APR 30 2019

				Packaging 3 - 11 - B4B					
				Packaging 3 - 12 - B4B					
				Packaging 3 - 13 - B4B					
				Packaging 3 - 14 - B4B					
				Packaging 3 - 15 - B4B					
				Packaging 3 - 16 - B4B					
				Packaging 3 - 17 - B4B					
				Packaging 3 - 18 - B4B					
				Packaging 3 - 19 - B4B					
				Packaging 3 - 20 - B4B					
				Packaging 3 - 21 - B4B					
				Packaging 3 - 22 - B4B					
				Packaging 3 - 23 - B4B	PC	WAb. 1-7			
				Packaging 3 - 24 - B4B					
				Packaging 3 - 25 - B4B					
				Packaging 3 - 26 - B4B					
				Packaging 3 - 27 - B4B					
				Packaging 3 - 28 - B4B					
				Packaging 3 - 29 - B4B					
				Packaging 3 - 30 - B4B					
				Packaging 3 - 31 - B4B					
				Packaging 3 - 32 - B4B					
				Packaging 3 - 33 - B4B					
				Packaging 3 - 34 - B4B					
				Packaging 3 - 35 - B4B					
				Packaging 3 - 36 - B4B					
				160 QC 21 - SA	18 pcs	4/30/19	0.00 0.00	QC 21 - SA - 21	21 MAY 01 2019
								QC 21 - SA - 70	21
								QC 21 - SA - 53	21
				Part Op 100 - 1-Cut as per Dwg D3512 Descriptions: 110 - (QC2- Inspect parts off machine FAI/FAIB) 120 - (QC8- Inspect parts - second check) 130 - (Form as per dwg) 140 - (QC5- Inspect part completeness to step on W/O) 150 - (Identify as per dwg & Stock Location: _____), LOCATION: WA001-7 160 - (QC21- Final Inspection - Work Order Release)					
				Job BOM					
				Part / Item	Component Name	Quantity	Operation	Container	
				M304S18GA	304/316 .050 Sheet	1.6974 sf (.0943 ea)	100-Waterjet - Flow - 1	S123199 S159673	
				Job Allocations					
				Operation	Component Part	Required	Inventory	Allocated	
				100-Waterjet - Flow - 1	M304S18GA	2	182	0	
Part Specifications									
Specifications could not be found.									

INSPECTION SHEET

**DAS
40**

Rev	Date	Change	Revised by	Approved
A	14.07.31	New Issue	KJ	

Entered: [Signature] Date: JUN 20 2019

NCR No.

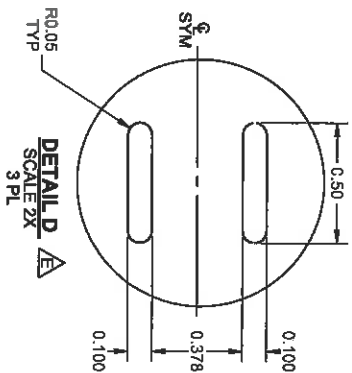
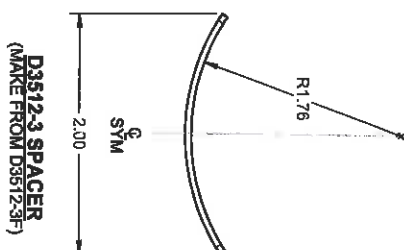
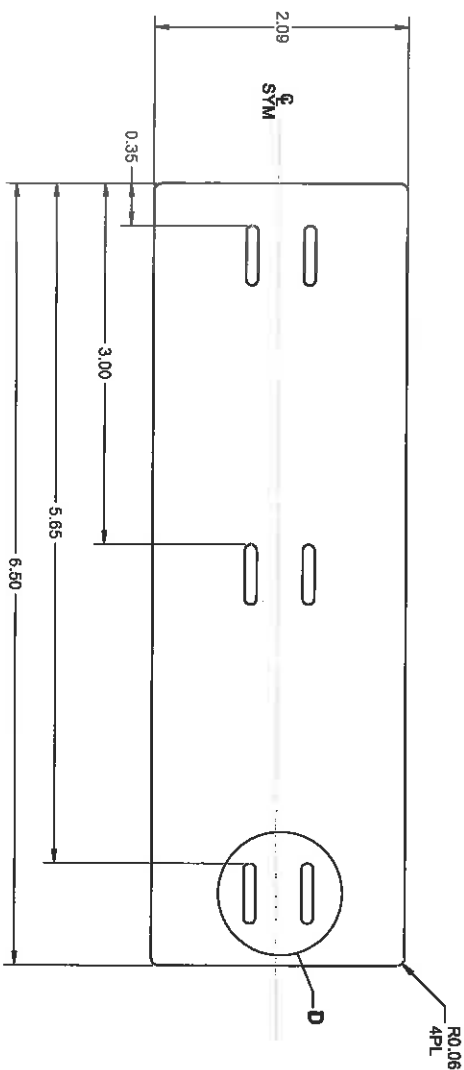
WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

Route update only



Job: <u>193653</u>		DISPOSITION		DEPARTMENT/PROCESS				Engineering	
Part No. <u>D3512-3</u>		Rework ☐ Scrap ☐ Use-as-is ☐		Skid-tube ☒ Machining ☐ Large Fab ☐		Cross tube ☐ Small Fab ☐ Finishing ☐		Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Water Jet ☐ Supplier ☐ Quality ☐	
Date:	Sequence #:	QTY Affected:		Disposition		Completed By		Lead hand / Supervisor	
Description Work Order Deviation		Description		Disposition		QC / QA Coordinator		APR 25 2019	
Flat pattern per D3512 Rev.D does not fit on Skid tube		Make D3512-31E per reference D3512 Rev.E attached to work order.		Additional weld Slots facilitate assembly and produce no change to final design		DAS 40 68		APR 25 2019	
Root Cause		FAULT CATEGORY		Positioned Wrong		QC / QA Coordinator		APR 25 2019	
Operator ☒ Manufacturing Process ☒ Equip/Tooling ☐ Handling/Preservation ☐ Material ☒ Product Improvement ☒ Process Improvement ☐ Human Factors ☐		Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐		Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐		Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐		Outside Tolerance ☒ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread ☐	
Other/Details:									

REFERENCE ONLY
SPM
19/09/17



- NOTES:
- 1) MATERIAL: AISI 304/316 SS SHEET ANNEALED 18 GAUGE 0.060 THICK
PER MIL-S-8069 OR AMS 5513 OR 5524 OR ASTM A240 OR ASME SA240
REF DART SPEC. MS304S186A
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART CSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.006 TO 0.010 MAX
 - 6) IDENTIFICATION: NONE
 - 7) WEIGHT: 0.19 lbs

APPROVED BY DESIGN MANAGER

DESIGN	DW	DART AEROSPACE USA, INC.
DRAWN	SAD	HILLBORO, OR
CHECKED	RF	DRAWING NO.
MFG. APPR.	DD	D3512
APPROVED	VS	TITLE
DE APPR.		WEARPLATE ASSY
DATE	18.03.07	SCALE
		MTS

Steven Drouin

From: Chris Provencal
Sent: Wednesday, April 17, 2019 2:13 PM
To: Steven Drouin
Subject: D3512-1/-3 wearplate deviation

Steve,

For D3512-1/-3 wearplates, it is acceptable to deviate future wearplates per the deviations of S/N 191932 / 191612

Sincerely,

Chris Provencal, P.Eng
Senior Engineer

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